

Date: Thursday, 24/08/2006 8:24:33 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 155 BRACKET
Job Number	: 28310		
Estimate Number	: 11040		
P.O. Number	: N/A	Part Number	: D28042
This Issue	: 24/08/2006 S.O. No. : N/A	Drawing Number	: D2804 REV B
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 28302	Material	: N/A
Written By	:	Due Date	: 31/08/2006 Qty: 8 Um: Each
Checked & Approved By	:		
Comment	: Est. A00.11.06 New Issue EC Est. B06.05.30 Blanks on wjetEC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
		 Comment: Qty.: 0.7875 f(s)/Unit Total : 6.3000 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50" Batch: M10263
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Template DT8534 Dwg Rev: B Prog Rev: B
		 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: SECOND CHECK
5.0	QC8	SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/01/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STA 155 BRACKET

Job Number: 28310

Part Number: D28042

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

ER 06/08/29 X 8

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/08/29 ⑧

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST469

BB 06/08/31 ⑧ ⑧ ⑧

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DC 06/08/01 ⑧

Job Completion



06/08/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

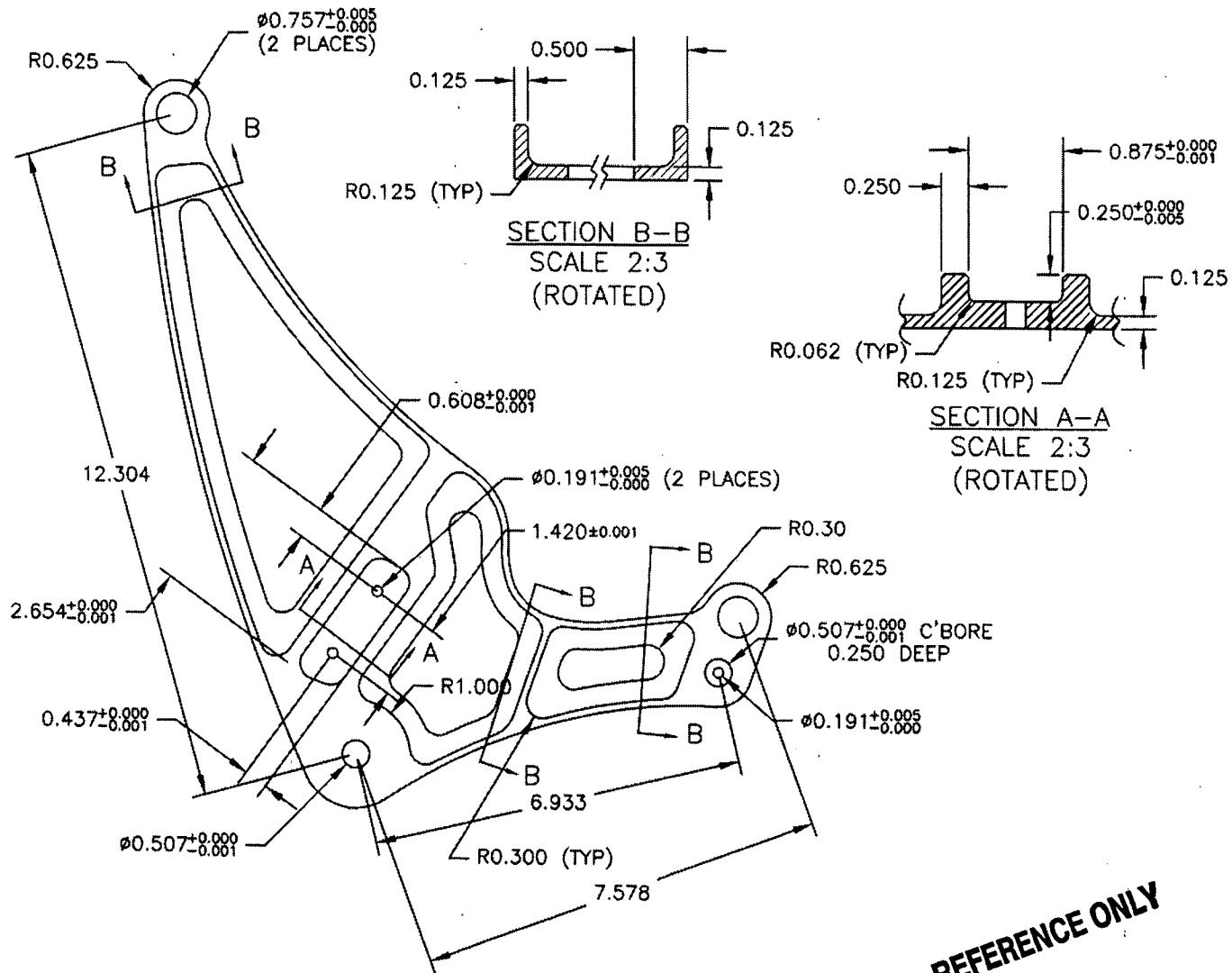
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3
		A 00.11.07 NEW ISSUE	
		B 04.11.22 ADD CUTOUTS & -043/-044	

**RELEASED***05-03-11***D2804-1 BRACKET (SHOWN), D2804-2 BRACKET (OPPOSITE)**

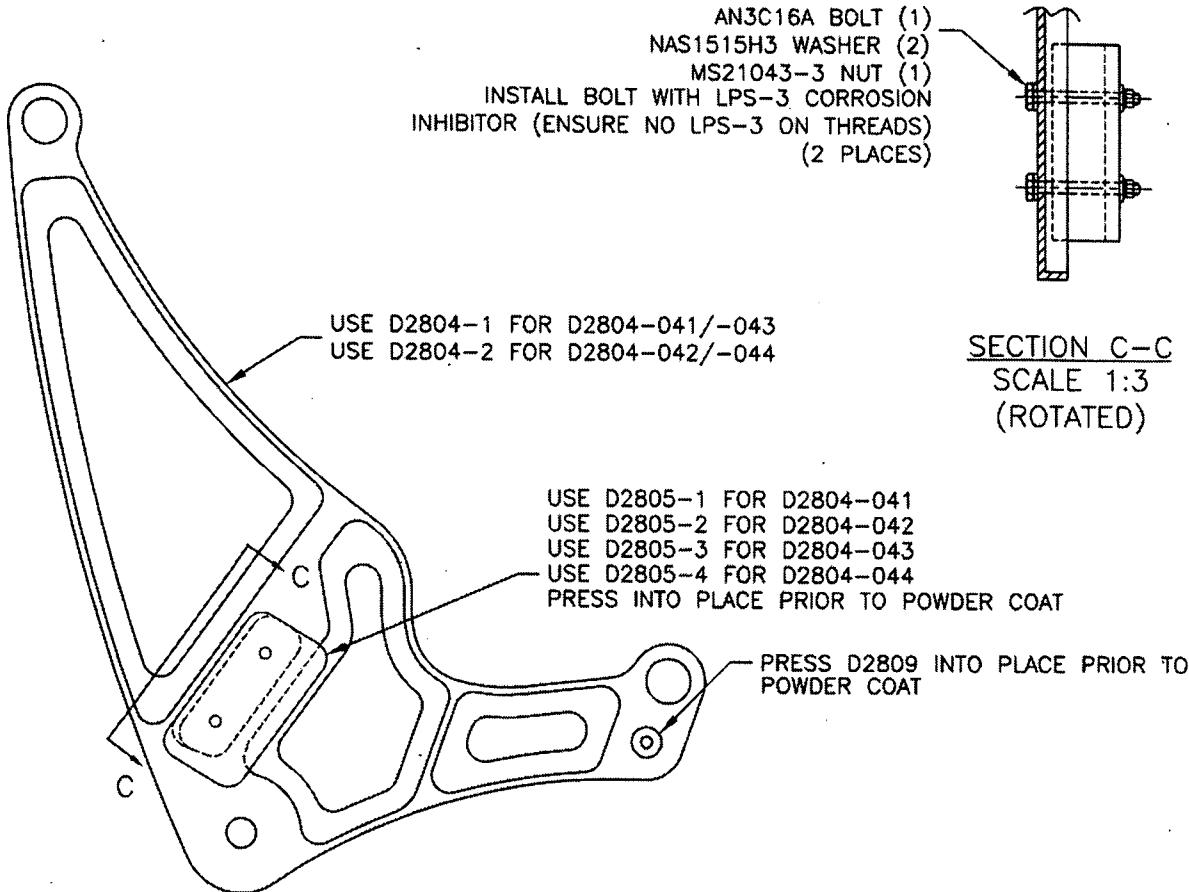
- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 – 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. B	SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3	



REFERENCE ONLY  
RELEASED  
05-03-11 *[Signature]*

D2804-041/-043 BRACKET ASS'Y (SHOWN),  
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>28310</b>
<b>Description:</b> STA 155 Bracket	<b>Part Number:</b>	<b>D2804-2</b>
<b>Inspection Dwg:</b> D2804 <b>Rev:</b> B		<b>Page 1 of 1</b>

# **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

<b>Measured by:</b>	J.L.	<b>Audited by:</b>	<i>JWL</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06/08/24	<b>Date:</b>	06/08/25	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	